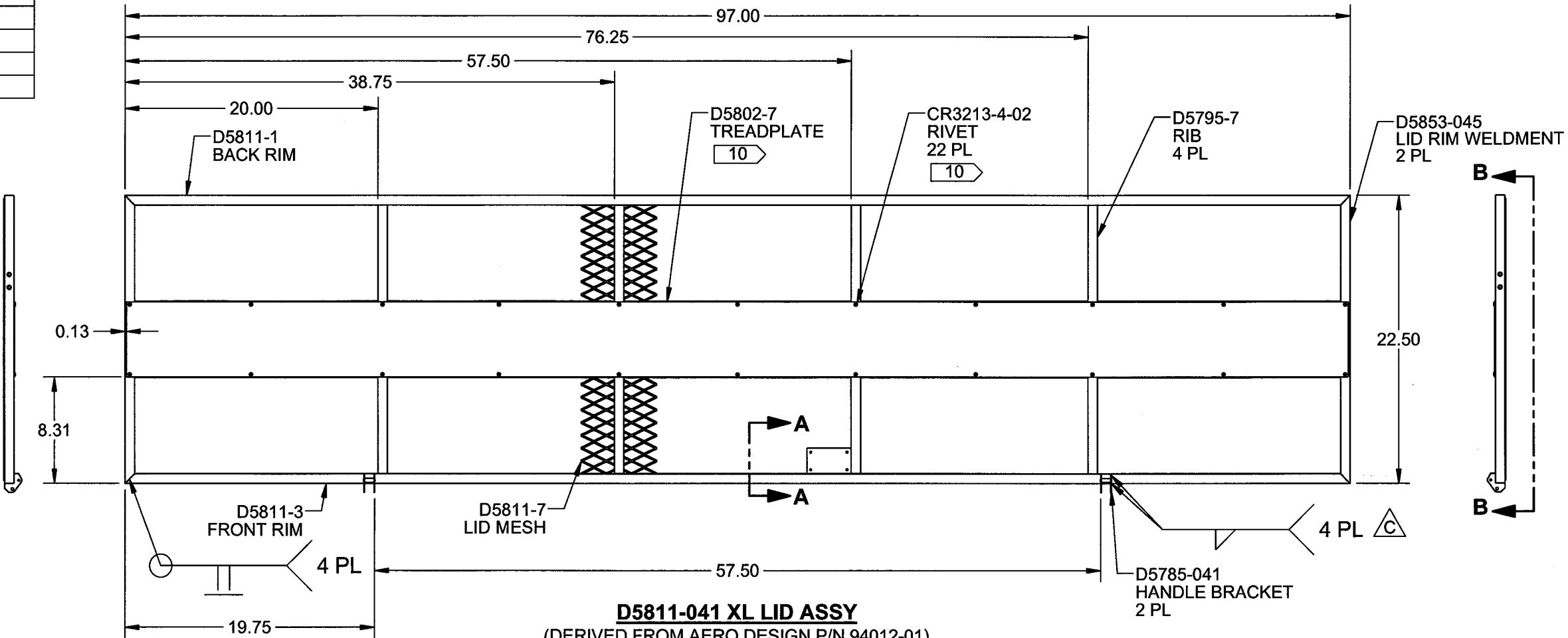


QTY -041	P/N	DESCRIPTION
X	D5811-041	XL LID ASSY
2	D5785-041	HANDLE BRACKET
4	D5795-7	RIB
6	D5795-11	STRINGER
1	D5795-15	PLACARD BRACKET
1	D5802-7	TREADPLATE
1	D5811-1	BACK RIM
1	D5811-3	FRONT RIM
4	D5811-5	STRINGER
1	D5811-7	LID MESH
2	D5853-045	LID RIM WELDMENT
22	CR3213-4-02	RIVET



D5811-041 XL LID ASSY
(DERIVED FROM AERO DESIGN P/N 94012-01)
(MESH SHOWN LOCALLY FOR CLARITY)

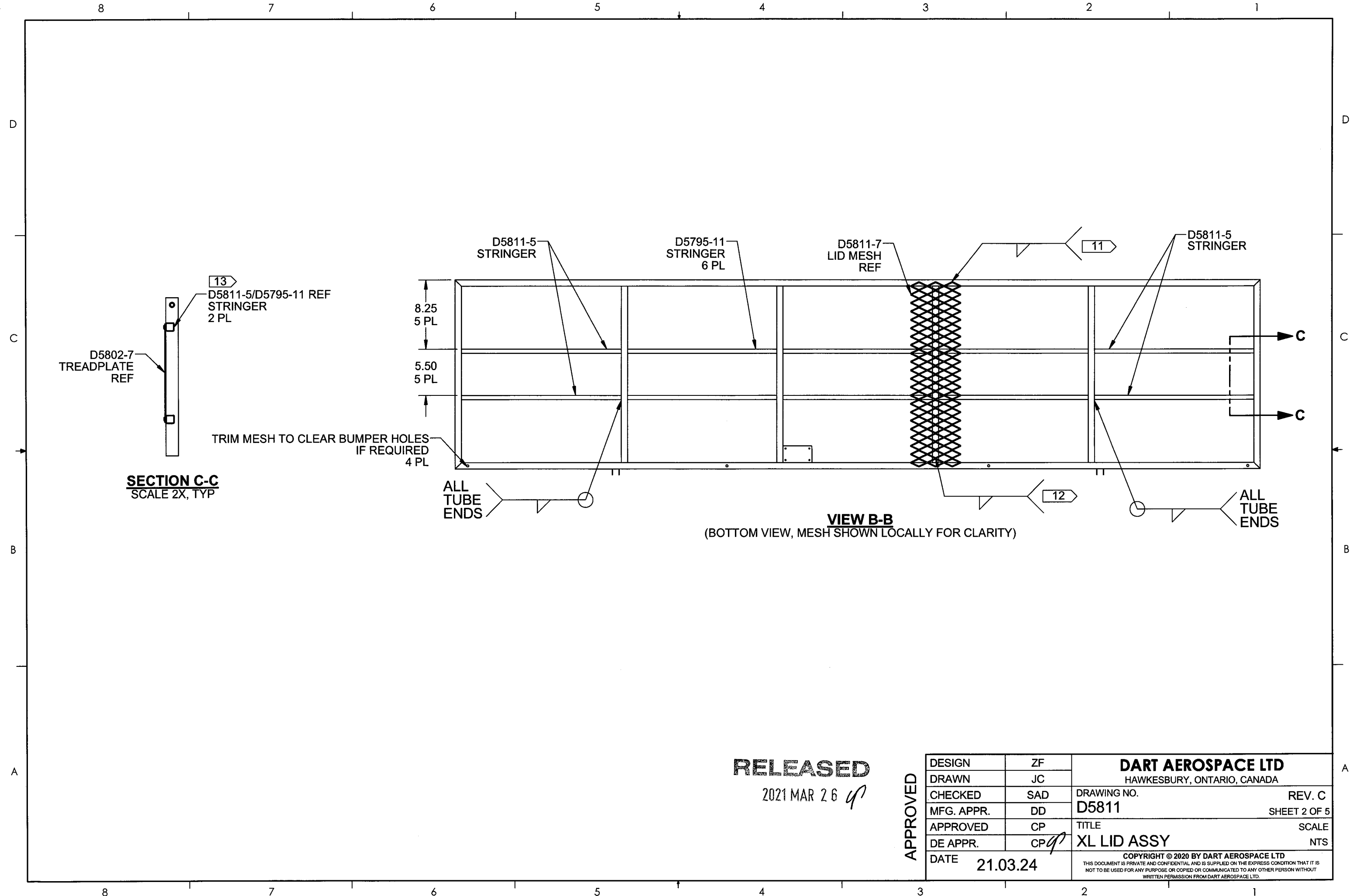
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 23.44 lbs
 - 8) WELD PER DART QSI 004. IT IS PERMISSIBLE TO GRIND OR BUFF TO CLEAN UP WELDS
 - 9) DRILL #30 ($\phi 0.129$) VENT HOLES AS REQUIRED. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD PRIOR TO FINISH.
 - 10) INSTALL TREADPLATE AFTER FINISH. TRANSFER MARK AND DRILL HOLES $\phi 0.129 +0.003/-0.000$ FROM TREADPLATE TO LID. FAY SEAL SURFACES BETWEEN LID AND TREADPLATE WITH RTV SILICONE. SECURE TREADPLATE WITH RIVETS.
 - 11) WELD EVERY MESH INTERSECTION ALONG RIM.
 - 12) FOR EACH RIB, WELD FIRST 5 MESH INTERSECTIONS DOWN EACH END THEN EVERY 2ND MESH INTERSECTION MINIMUM.
 - 13) ALIGN STRINGERS TO TOP OF LID.
 - 14) LOCATE D5795-15 PLACARD BRACKET FLUSH WITH BOTTOM OF LID. TRIM MESH TO CLEAR BRACKET LEAVING 0.25 OVERLAP. WELD MESH TO BRACKET.

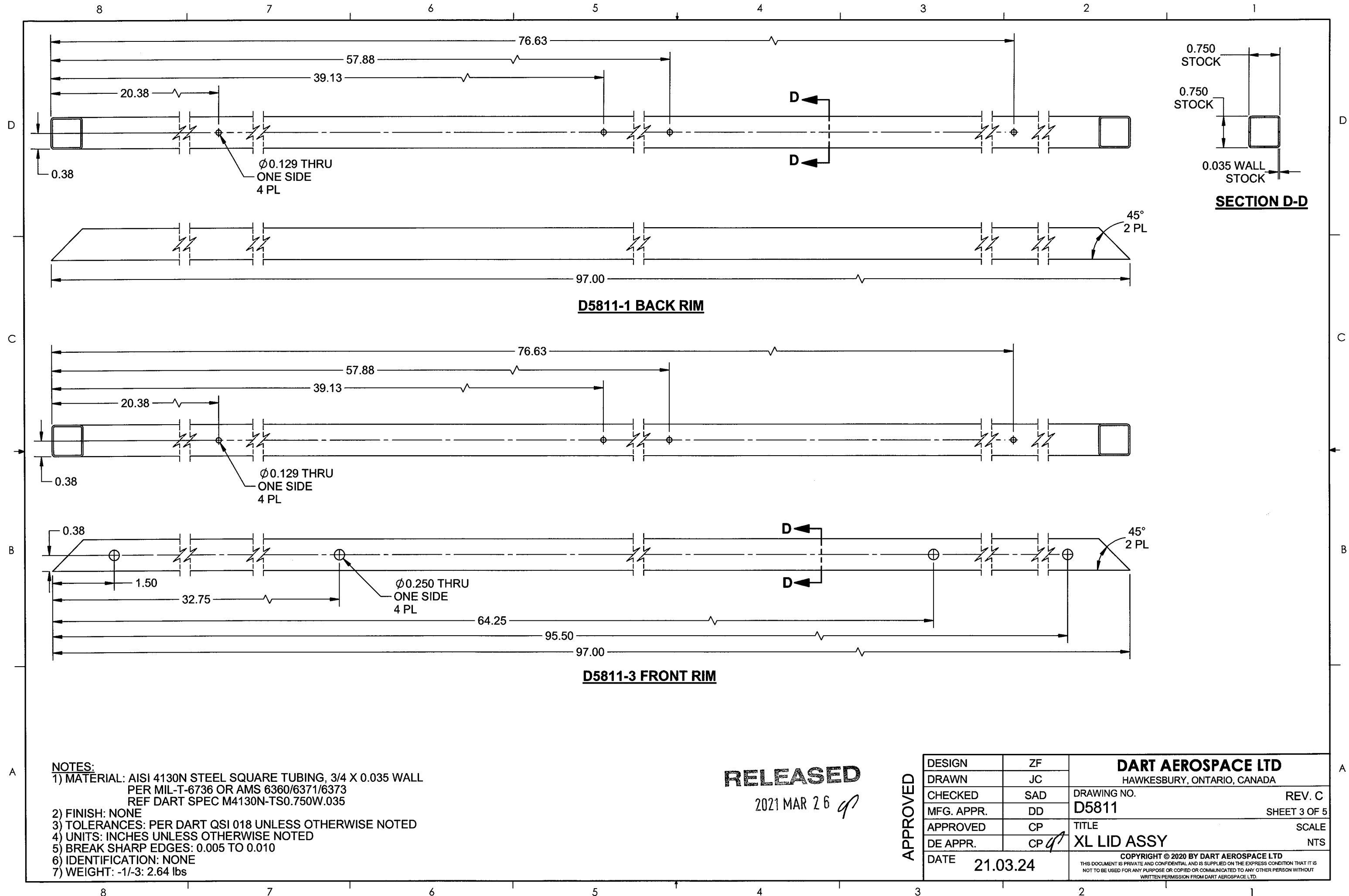
RELEASED

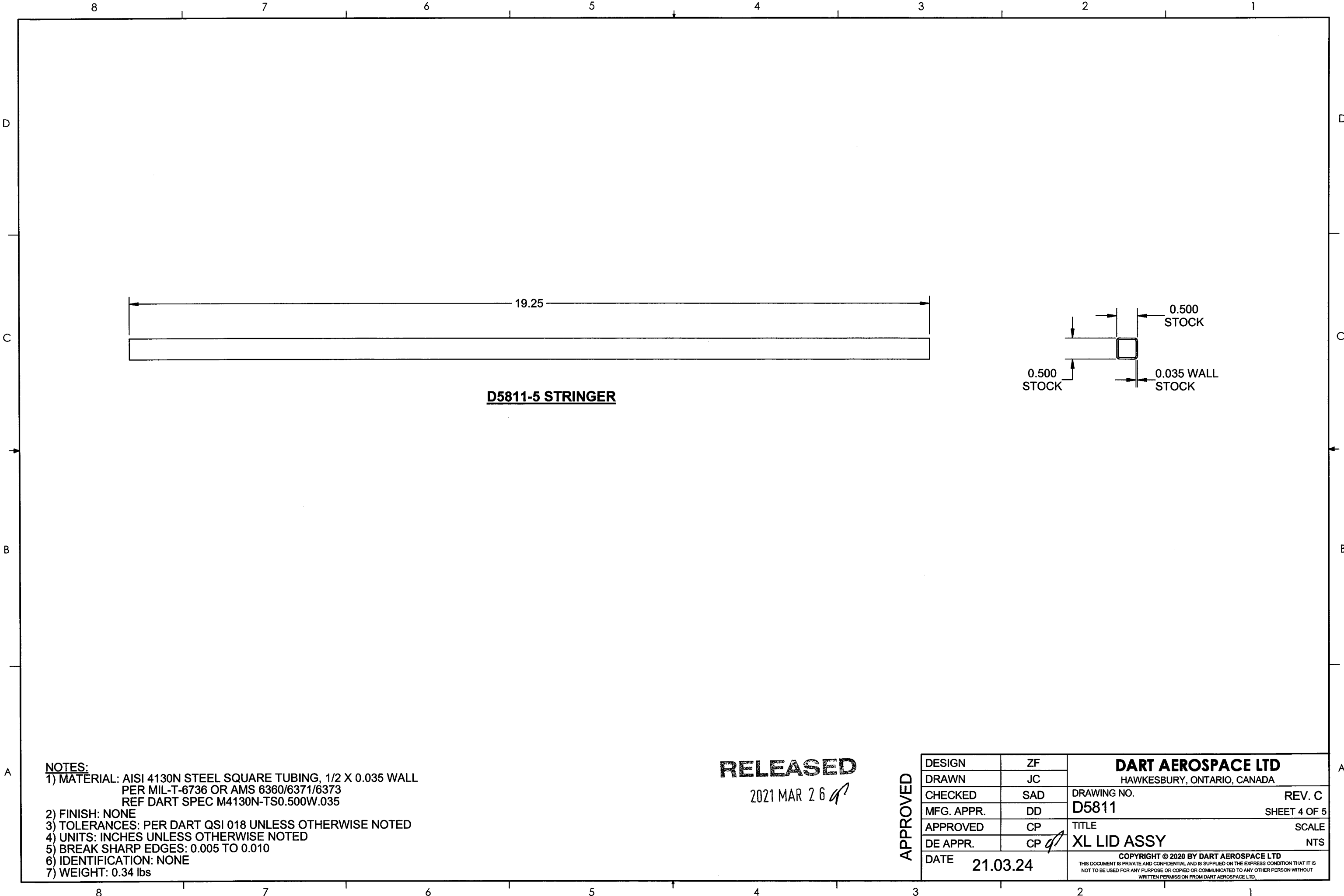
2021 MAR 26
H3 ECR 2021-152

APPROVED

C	SHT 1 ZNB1: UPDATED WELD SYMBOL	JC	21.03.24
B	SHT 1: REMOVED NOTE 13. SHT 2 ZNC3: REMOVED WELD SYMBOL FOR MESH TO STRINGER. SHT 3&4: UPDATED NOTE 1. SHT 5: ADDED NOTE 8	JC	20.12.03
A	NEW ISSUE	ZF	20.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO.	REV. C
MFG. APPR.	DD	D5811	SHEET 1 OF 5
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	XL LID ASSY	NTS
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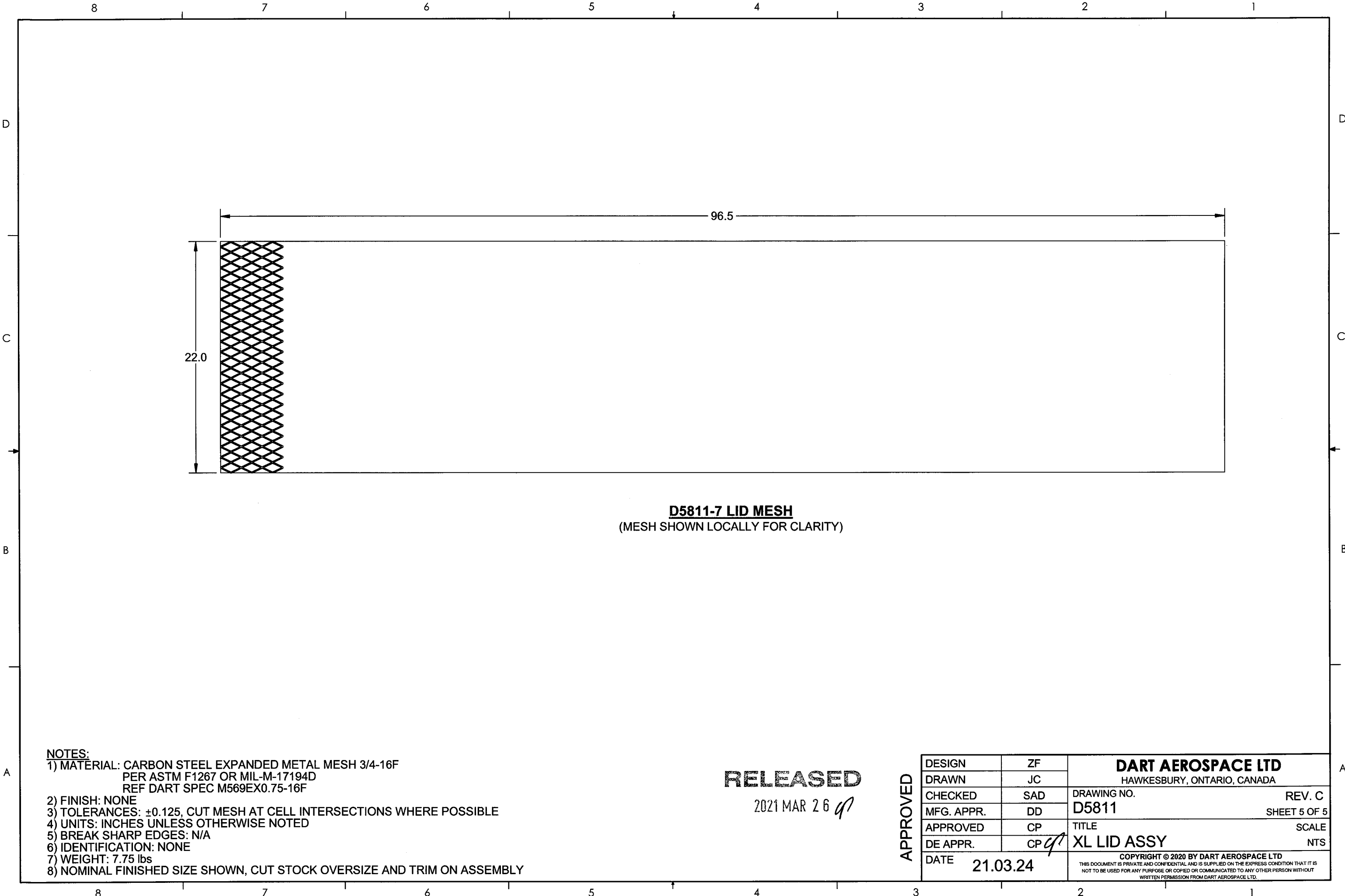


NOTES:
1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL
PER MIL-T-6736 OR AMS 6360/6371/6373
REF DART SPEC M4130N-TS0.500W.035
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 0.34 lbs

RELEASED
2021 MAR 26

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DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO.	REV. C
MFG. APPR.	DD	D5811	SHEET 4 OF 5
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	XL LID ASSY	NTS
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D5811-7 LID MESH
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: CARBON STEEL EXPANDED METAL MESH 3/4-16F
PER ASTM F1267 OR MIL-M-17194D
REF DART SPEC M569EX0.75-16F
 - 2) FINISH: NONE
 - 3) TOLERANCES: ±0.125, CUT MESH AT CELL INTERSECTIONS WHERE POSSIBLE
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.75 lbs
 - 8) NOMINAL FINISHED SIZE SHOWN, CUT STOCK OVERSIZE AND TRIM ON ASSEMBLY

RELEASED
2021 MAR 26 *qp*

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DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. D5811	REV. C
MFG. APPR.	DD		SHEET 5 OF 5
APPROVED	CP	TITLE	SCALE
DE APPR.	CP <i>qp</i>	XL LID ASSY	NTS
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